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**LIGHTING APPARATUS WITH FLEXIBLE OLED AREA**  
**ILLUMINATION LIGHT SOURCE AND FIXTURE**

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**LIGHTING APPARATUS WITH FLEXIBLE OLED AREA  
ILLUMINATION LIGHT SOURCE AND FIXTURE**

**FIELD OF THE INVENTION**

5                   The present invention relates to the use of organic light emitting diodes for area illumination.

**BACKGROUND OF THE INVENTION**

10                   Solid-state lighting devices made of light emitting diodes are increasingly useful for applications requiring robustness and long-life. For example, solid-state LEDs are found today in automotive applications. These devices are typically formed by combining multiple, small LED devices providing a point light source into a single module together with glass lenses suitably designed to control the light as is desired for a particular application (see, for  
15                   example WO99/57945, published November 11, 1999). These multiple devices are expensive and complex to manufacture and integrate into single area illumination devices. Moreover, LED devices provide point sources of light that are not preferred for area illumination.

20                   Conventional illumination devices such as incandescent or fluorescent light bulbs are bulky, fragile, and problematic to handle and ship. Although the bulbs are filled with gas, the glass tubes are easily broken and occupy substantial space, especially in comparison to the actual light emitting area or material of the device. The bulbs must be carefully packed and require a large volume for shipping.

25                   Existing solid-state lighting elements may be planar and hence easy and cost-effective to ship but do not address the need for lighting elements that have a variety of conventional three-dimensional shapes as found, for example, in light bulbs for decorative lighting. It is also useful if a lighting device is readily and safely replaced by consumers at minimal cost.

30                   There is a need therefore for an improved, replaceable OLED area illumination device having a simple construction using a single substrate, is

compatible with the existing lighting infrastructure, is efficient to ship, and provides a variety of three-dimensional shapes.

### **SUMMARY OF THE INVENTION**

5           The need is met by providing lighting apparatus that includes a solid-state area illumination light source, having: a planar flexible substrate, a flexible organic light emitting diode (OLED) layer deposited on the flexible substrate, the organic light emitting diode layer including first and second electrodes for providing electrical power to the OLED layer, a flexible  
10   encapsulating cover covering the OLED layer, and first and second conductors electrically connected to the first and second electrodes, and extending beyond the encapsulating cover for making electrical contact to the first and second electrodes by an external power source, whereby the light source may be stored in a space saving planar configuration; and a lighting fixture for removably receiving and  
15   holding the light source in a curved 3 dimensional configuration, the lighting fixture including a support for holding the light source in the curved configuration and contacts for providing electrical contact between said first and second conductors and an external power source.

### **ADVANTAGES**

20           The present invention has the advantage of providing a lighting apparatus having a light source that can be stored efficiently in a planar configuration, thereby saving considerable storage space. Another advantage is that the planar flexible light sources are not fragile and can be packaged in thin,  
25   unpadded packaging.

### **BRIEF DESCRIPTION OF THE DRAWINGS**

Fig. 1 illustrates a partial cross section of a prior art conventional OLED illumination device;

Fig. 2 is a perspective view of a flexible area illumination light source, including a detail of the layer structure, according to one embodiment of the present invention;

5 Fig. 3 is a perspective view of the flexible light source of Fig. 2 shown in a curved configuration;

Fig. 4 is a perspective view of a lighting fixture for holding the light source of Fig. 3 in its curved configuration;

Fig. 5 is a top view of the lighting fixture and light source showing clips for holding the light source in the curved configuration;

10 Fig. 6 is a perspective view of a light source and lighting fixture according to an alternative embodiment of the present invention;

Fig. 7 is a perspective view of an alternative embodiment of a light source useable according to the present invention;

15 Fig. 8 is a perspective view of a further alternative embodiment of a light source useable according to the present invention;

Fig. 9 is a perspective view of a lighting fixture holding a plurality of flexible light sources according to a further alternative embodiment of the present invention;

20 Fig. 10 is a perspective view of a light source held in a spiral configuration according to the present invention;

Fig. 11 is a perspective view of a light source held in a conical configuration according to the present invention;

Fig. 12 is a perspective view of a light source and lighting fixture having a standard base.

25 Fig. 13 is a perspective view of lighting apparatus according to the present invention including a light transmissive housing according to one embodiment of the present invention;

Fig. 14 is a perspective view of a stack of flexible light sources according to the present invention; and

30 Fig. 15 is a cross sectional view of an OLED light source as known in the prior art.

It will be understood that the figures are not to scale since the individual layers are too thin and the thickness differences of various layers too great to permit depiction to scale.

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## DETAILED DESCRIPTION OF THE INVENTION

Fig. 1 is a schematic diagram of a prior art OLED light source **10** including an organic light emitting layer **12** disposed between two electrodes, e.g. a cathode **14** and an anode **16**. The organic light emitting layer **12** emits light upon application of a voltage from a power source **18** across the electrodes. The  
10 OLED light source **10** typically includes a substrate **20** such as glass or plastic. It will be understood that the relative locations of the anode **16** and cathode **14** may be reversed with respect to the substrate. The term OLED light source refers to the combination of the organic light emitting layer **12**, the cathode **14**, the anode **16**, and other layers described below.

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Referring to Fig. 2, a solid-state area illumination light source, includes a planar flexible substrate **20**, a flexible organic light emitting diode (OLED) layer **12** deposited on the flexible substrate, the organic light emitting diode layer including first and second electrodes **14** and **16** for providing electrical power to the OLED layer, a flexible encapsulating cover **30** covering the OLED  
20 layer, first and second conductors **24** and **26** electrically connected to the first and second electrodes, and extending beyond the encapsulating cover **30** for making electrical contact to the first and second electrodes **14** and **16** by an external power source, whereby the light source may be stored in a space saving planar configuration. The encapsulating cover may be a coated layer or an additional  
25 layer of material affixed over the OLED layers and sealed at the edges of the devices. Light may be emitted either through the substrate or the cover, or both, if they are transparent. The OLED layers themselves are continuous over the substrate to form a single contiguous light-emitting area. As shown in Fig. 3, the flexible substrate **20** can be curved into a three dimensional form and, as shown in  
30 Fig. 4, inserted into an aperture **36** in a lighting fixture **34** for removably receiving and holding the light source **10** in a curved three-dimensional configuration. The

lighting fixture includes a support 38 having clips 39 for holding the light source in the curved configuration, and contacts 40 within the aperture 36 for providing electrical contact between the first and second conductors and an external power source.

5                   The support 38 may be transparent. In one embodiment of the present invention, the flexible substrate 20 can define a tab portion 21 that may include an orientation feature such as step 28 to insure that the light source is inserted in the fixture in the correct orientation. The tab portion 21 can be inserted into the aperture 36 of the fixture 34 and the light source 10 shaped around the  
10                   support 38. Alternatively, additional contacts may be included in the aperture or on either side of the flexible substrate using conductive vias to provide electrical contact with the conductors regardless of the orientation in which the tab is inserted (not shown).

                  The flexible substrate 20 may be fastened to the support 38 with,  
15                   for example, an adhesive, hook loop fasteners, or a mechanical restraint such as a clip or detent. In applications where it is not required to emit light from both sides of the substrate, one or more of the substrate, cover, anode, or cathode may be opaque or reflective. The light source 10 may be physically inserted into or removed from the fixture by pushing or pulling the substrate 20 into or out of the  
20                   aperture 36.

                  Fig. 5 shows a top view of the support 38 with clips 39 for holding edges of the light source 10. To install the light source 10 in fixture 34, the tab portion 21 is first inserted into the aperture 36. Next, the light source 10 is wrapped around the support 38 and the edges of the flexible light source 10 are  
25                   inserted under clips 39 as shown by arrow A.

                  Referring to Fig. 6, in another embodiment, the flexible substrate 20 may define two tabs 21 and 22. The first and second conductors 24 and 26 are each located on a respective tab portion and structured to fit into complementary apertures 36 and 36' in a fixture 34. The fixture 34 includes one or more fins 41  
30                   for supporting the flexible light source 10.

Referring to Fig. 7 in a further embodiment, the substrate **20** does not define a physical protrusion but includes first and second conductors **24** and **26** located on an edge of the substrate **20**. Fig. 8 illustrates an alternative arrangement wherein the first and second conductors **24** and **26** are at opposite edges of the substrate **20**. In the embodiments shown in Figs 7 and 8, the apertures in the lighting fixture are wide enough to receive the entire edge of the substrate. Alternatively, the support can include clamps for holding two or more edges of the light source to bow the light source into a three-dimensional configuration, for example a cylindrical configuration. The contacts in the lighting fixture may be located in the clamps. A wide variety of other configurations are readily designed, including rings or conical sections.

Referring to Fig. 9, an alternative fixture and support are shown wherein two light sources **10** are held in a common fixture **34**. The half cylinder configurations shown in Figs. 6 and 9 are useful, for example, for under-shelf lighting.

Fig. 10 illustrates another embodiment wherein the body of the light source **10** has an elongated rectangular shape and is held in a spiral configuration by the fixture **34**. Clips **39** are provided at both ends of the spiral for holding the light source. Fig. 11 shows an embodiment wherein the light source **10** is held in the shape of a cone by fixture **34**.

Referring to Fig. 4, the lighting fixture **34** can be adapted to connect the OLED light source **10** to an external power source (such as a standard household electrical grid, not shown). The fixture **34** may include power-conditioning circuitry **50** to convert the electrical power from the external power source to a form suitable for powering the OLED light source **10**. For example, the OLED light source **10** may require a rectified voltage with a particular waveform and magnitude; the power conditioning circuitry can provide the particular waveform using conventional power control circuitry. The particular waveform may periodically reverse bias the light emitting organic materials to prolong the life time of the OLED materials. The fixture may also include a switch (not shown) for controlling the power to the light source.

The brightness of the light source **10** may be controlled by varying the power provided to the OLED. In particular, pulse-width modulation schemes well known in the art may be employed (see for example, EP1094436A2, published April 25, 2001) and implemented by the power conditioning circuitry

5 **50**. Alternatively, the amount of power provided to the light emitting area may be reduced, for example by reducing the voltage or limiting the current supplied to the OLED. A brightness control switch may be integrated into the socket, for example with variable resistance switch formed. The power source may be standard 110 volt AC as found in North America, 220 volt AC as found in Europe,  
10 or other standard power configurations such as 24-, 12-, or 6-volt DC.

The OLED light source **10** can be provided as a standard element and fixtures **34** customized to markets with differing power systems. OLED light sources **10** may be provided with different shapes or other attributes useful in specific applications and may be employed with a common socket, thereby  
15 decreasing costs and improving usefulness of the lighting apparatus.

Referring to Fig. 12, the lighting fixture **34** may include a support portion **38** and a standard light bulb base **44** such as a US standard screw type lamp base as shown in Fig. 12, or a pin-type base (not shown). A wide variety of standard lamp bases are known in the prior art and may be used with the fixture of  
20 the present invention.

Referring to Fig. 13, a transparent or translucent screen or housing **52** may be provided around the OLED light source **10** to diffuse the light and provide additional physical protection and cosmetic appeal. The housing may take a variety of shapes, for example the shape of a standard light bulb.

25 Referring to Fig. 14, the flexible light sources **10** may be stacked and packed in a planar configuration for compact storage and shipment. This compact packing arrangement significantly reduces the packing volume necessary for traditional bulbs and provides a robust, sturdy means for storing, transporting, and stocking the lighting light sources **10**.

30 The present invention may be employed in a wide variety of conventional applications, for example in a table-top lamp, floor-lamp, ceiling



lamp, or chandelier. The present invention may also be employed in portable illumination devices using DC power sources.

In a preferred embodiment, the Organic Light Emitting Diode layers (OLED layers) are composed of small molecule OLEDs as disclosed in but  
5 not limited to US Patent 4,769,292, issued September 6, 1988 to Tang et al., and US Patent 5,061,569, issued October 29, 1991 to VanSlyke et al.

#### OLED Element architecture

There are numerous configurations of OLED elements wherein the present invention can be successfully practiced. A typical, non-limiting structure  
10 is shown in Figure 15 and is comprised of an anode layer 103, a hole-injecting layer 105, a hole-transporting layer 107, a light-emitting layer 109, an electron-transporting layer 111, and a cathode layer 113. These layers are described in detail below. The total combined thickness of the organic layers is preferably less than 500 nm. A voltage/current source 250 is required to energize the OLED  
15 element and conductive wiring 260 is required to make electrical contact to the anode and cathode. The TFT layers and associated wiring serve these functions.

#### Substrate

Substrate 20 is preferably light transmissive but may also be  
20 opaque. Substrates for use in this case include, but are not limited to, very thin glass and plastics.

#### Anode

The anode layer 103 is preferably transparent or substantially transparent to the light emitted by the OLED layer(s). Common transparent anode  
25 materials used in this invention are indium-tin oxide (ITO), indium-zinc oxide (IZO) and tin oxide, but other metal oxides can work including, but not limited to, aluminum- or indium-doped zinc oxide, magnesium-indium oxide, and nickel-tungsten oxide. In addition to these oxides, metal nitrides, such as gallium nitride, and metal selenides, such as zinc selenide, and metal sulfides, such as zinc sulfide,  
30 can be used in layer 103. When the anode is not transparent, the light transmitting characteristics of layer 103 are immaterial and any conductive material can be

used, transparent, opaque or reflective. Example conductors for this application include, but are not limited to, gold, iridium, molybdenum, palladium, and platinum. Typical anode materials, transmissive or otherwise, have a work function of 4.1 eV or greater. Desired anode materials are commonly deposited  
5 by any suitable means such as evaporation, sputtering, chemical vapor deposition, or electrochemical means. Anodes can be patterned using well-known photolithographic processes.

#### Hole-Injecting Layer (HIL)

It is often useful that a hole-injecting layer 105 be provided  
10 between anode 103 and hole-transporting layer 107. The hole-injecting material can serve to improve the film formation property of subsequent organic layers and to facilitate injection of holes into the hole-transporting layer. Suitable materials for use in the hole-injecting layer include, but are not limited to, porphyrinic compounds as described in US 4,720,432, and plasma-deposited fluorocarbon  
15 polymers as described in US 6,208,075. Alternative hole-injecting materials reportedly useful in organic EL devices are described in EP 0 891 121 A1 and EP 1 029 909 A1.

#### Hole-Transporting Layer (HTL)

The hole-transporting layer 107 contains at least one hole-  
20 transporting compound such as an aromatic tertiary amine, where the latter is understood to be a compound containing at least one trivalent nitrogen atom that is bonded only to carbon atoms, at least one of which is a member of an aromatic ring. In one form the aromatic tertiary amine can be an arylamine, such as a monoarylamine, diarylamine, triarylamine, or a polymeric arylamine. Exemplary  
25 monomeric triarylaminers are illustrated by Klupfel et al. US 3,180,730. Other suitable triarylaminers substituted with one or more vinyl radicals and/or comprising at least one active hydrogen containing group are disclosed by Brantley et al US 3,567,450 and US 3,658,520. A more preferred class of aromatic tertiary amines are those which include at least two aromatic tertiary  
30 amine moieties as described in US 4,720,432 and US 5,061,569. Illustrative of useful aromatic tertiary amines include, but are not limited to, the following:

- 1,1-Bis(4-di-*p*-tolylaminophenyl)cyclohexane  
 1,1-Bis(4-di-*p*-tolylaminophenyl)-4-phenylcyclohexane  
 4,4'-Bis(diphenylamino)quadriphenyl  
 Bis(4-dimethylamino-2-methylphenyl)-phenylmethane  
 5 N,N,N-Tri(*p*-tolyl)amine  
 4-(di-*p*-tolylamino)-4'-[4(di-*p*-tolylamino)-styryl]stilbene  
 N,N,N',N'-Tetra-*p*-tolyl-4,4'-diaminobiphenyl  
 N,N,N',N'-Tetraphenyl-4,4'-diaminobiphenyl  
 N,N,N',N'-tetra-1-naphthyl-4,4'-diaminobiphenyl  
 10 N,N,N',N'-tetra-2-naphthyl-4,4'-diaminobiphenyl  
 N-Phenylcarbazole  
 4,4'-Bis[N-(1-naphthyl)-N-phenylamino]biphenyl  
 4,4'-Bis[N-(1-naphthyl)-N-(2-naphthyl)amino]biphenyl  
 4,4''-Bis[N-(1-naphthyl)-N-phenylamino]*p*-terphenyl  
 15 4,4'-Bis[N-(2-naphthyl)-N-phenylamino]biphenyl  
 4,4'-Bis[N-(3-acenaphthenyl)-N-phenylamino]biphenyl  
 1,5-Bis[N-(1-naphthyl)-N-phenylamino]naphthalene  
 4,4'-Bis[N-(9-anthryl)-N-phenylamino]biphenyl  
 4,4''-Bis[N-(1-anthryl)-N-phenylamino]-*p*-terphenyl  
 20 4,4'-Bis[N-(2-phenanthryl)-N-phenylamino]biphenyl  
 4,4'-Bis[N-(8-fluoranthryl)-N-phenylamino]biphenyl  
 4,4'-Bis[N-(2-pyrenyl)-N-phenylamino]biphenyl  
 4,4'-Bis[N-(2-naphthacenyl)-N-phenylamino]biphenyl  
 4,4'-Bis[N-(2-perylenyl)-N-phenylamino]biphenyl  
 25 4,4'-Bis[N-(1-coronenyl)-N-phenylamino]biphenyl  
 2,6-Bis(di-*p*-tolylamino)naphthalene  
 2,6-Bis[di-(1-naphthyl)amino]naphthalene  
 2,6-Bis[N-(1-naphthyl)-N-(2-naphthyl)amino]naphthalene  
 N,N,N',N'-Tetra(2-naphthyl)-4,4''-diamino-*p*-terphenyl  
 30 4,4'-Bis{N-phenyl-N-[4-(1-naphthyl)-phenyl]amino}biphenyl  
 4,4'-Bis[N-phenyl-N-(2-pyrenyl)amino]biphenyl

2,6-Bis[N,N-di(2-naphthyl)amine]fluorene

1,5-Bis[N-(1-naphthyl)-N-phenylamino]naphthalene

Another class of useful hole-transporting materials includes polycyclic aromatic compounds as described in EP 1 009 041. In addition, polymeric hole-transporting materials can be used such as poly(N-vinylcarbazole) (PVK), polythiophenes, polypyrrole, polyaniline, and copolymers such as poly(3,4-ethylenedioxythiophene) / poly(4-styrenesulfonate) also called PEDOT/PSS.

#### Light-Emitting Layer (LEL)

As more fully described in US 4,769,292 and 5,935,721, the light-emitting layer (LEL) 109 of the organic EL element comprises a luminescent or fluorescent material where electroluminescence is produced as a result of electron-hole pair recombination in this region. The light-emitting layer can be comprised of a single material, but more commonly consists of a host material doped with a guest compound or compounds where light emission comes primarily from the dopant and can be of any color. The host materials in the light-emitting layer can be an electron-transporting material, as defined below, a hole-transporting material, as defined above, or another material or combination of materials that support hole-electron recombination. The dopant is usually chosen from highly fluorescent dyes, but phosphorescent compounds, e.g., transition metal complexes as described in WO 98/55561, WO 00/18851, WO 00/57676, and WO 00/70655 are also useful. Dopants are typically coated as 0.01 to 10 % by weight into the host material. Iridium complexes of phenylpyridine and its derivatives are particularly useful luminescent dopants. Polymeric materials such as polyfluorenes and polyvinylarylenes (e.g., poly(p-phenylenevinylene), PPV) can also be used as the host material. In this case, small molecule dopants can be molecularly dispersed into the polymeric host, or the dopant could be added by copolymerizing a minor constituent into the host polymer.

An important relationship for choosing a dye as a dopant is a comparison of the bandgap potential which is defined as the energy difference between the highest occupied molecular orbital and the lowest unoccupied

molecular orbital of the molecule. For efficient energy transfer from the host to the dopant molecule, a necessary condition is that the band gap of the dopant is smaller than that of the host material.

Host and emitting molecules known to be of use include, but are not limited to, those disclosed in US 4,768,292, US 5,141,671, US 5,150,006, US 5,151,629, US 5,405,709, US 5,484,922, US 5,593,788, US 5,645,948, US 5,683,823, US 5,755,999, US 5,928,802, US 5,935,720, US 5,935,721, and US 6,020,078.

Metal complexes of 8-hydroxyquinoline and similar oxine derivatives constitute one class of useful host compounds capable of supporting electroluminescence, and are particularly suitable. Illustrative of useful chelated oxinoid compounds are the following:

- CO-1: Aluminum trisoxine [alias, tris(8-quinolinolato)aluminum(III)]
- CO-2: Magnesium bisoxine [alias, bis(8-quinolinolato)magnesium(II)]
- CO-3: Bis[benzo{f}-8-quinolinolato]zinc (II)
- CO-4: Bis(2-methyl-8-quinolinolato)aluminum(III)- $\mu$ -oxo-bis(2-methyl-8-quinolinolato) aluminum(III)
- CO-5: Indium trisoxine [alias, tris(8-quinolinolato)indium]
- CO-6: Aluminum tris(5-methyloxine) [alias, tris(5-methyl-8-quinolinolato) aluminum(III)]
- CO-7: Lithium oxine [alias, (8-quinolinolato)lithium(I)]
- CO-8: Gallium oxine [alias, tris(8-quinolinolato)gallium(III)]
- CO-9: Zirconium oxine [alias, tetra(8-quinolinolato)zirconium(IV)]

Other classes of useful host materials include, but are not limited to: derivatives of anthracene, such as 9,10-di-(2-naphthyl)anthracene and derivatives thereof, distyrylarylene derivatives as described in US 5,121,029, and benzazole derivatives, for example, 2, 2', 2''-(1,3,5-phenylene)tris[1-phenyl-1H-benzimidazole].

Useful fluorescent dopants include, but are not limited to, derivatives of anthracene, tetracene, xanthene, perylene, rubrene, coumarin,

rhodamine, quinacridone, dicyanomethylenepyran compounds, thiopyran compounds, polymethine compounds, pyrilium and thiapyrilium compounds, fluorene derivatives, perflanthene derivatives and carbostyryl compounds.

#### Electron-Transporting Layer (ETL)

5 Preferred thin film-forming materials for use in forming the electron-transporting layer **111** of the organic EL elements of this invention are metal chelated oxinoid compounds, including chelates of oxine itself (also commonly referred to as 8-quinolinol or 8-hydroxyquinoline). Such compounds help to inject and transport electrons, exhibit high levels of performance, and are  
10 readily fabricated in the form of thin films. Exemplary oxinoid compounds were listed previously.

Other electron-transporting materials include various butadiene derivatives as disclosed in U.S. Patent No. 4,356,429 and various heterocyclic optical brighteners as described in U.S. Patent No. 4,539,507. Benzazoles and  
15 triazines are also useful electron-transporting materials.

In some instances, layers **111** and **109** can optionally be collapsed into a single layer that serves the function of supporting both light emission and electron transport. These layers can be collapsed in both small molecule OLED systems and in polymeric OLED systems. For example, in polymeric systems, it  
20 is common to employ a hole-transporting layer such as PEDOT-PSS with a polymeric light-emitting layer such as PPV. In this system, PPV serves the function of supporting both light emission and electron transport.

#### Cathode

Preferably, the cathode **113** is transparent and can comprise nearly  
25 any conductive transparent material. Alternatively, the cathode **113** may be opaque or reflective. Suitable cathode materials have good film-forming properties to ensure good contact with the underlying organic layer, promote electron injection at low voltage, and have good stability. Useful cathode materials often contain a low work function metal ( $< 4.0$  eV) or metal alloy. One  
30 preferred cathode material is comprised of a Mg:Ag alloy wherein the percentage of silver is in the range of 1 to 20 %, as described in U.S. Patent No. 4,885,221.

Another suitable class of cathode materials includes bilayers comprising a thin electron-injection layer (EIL) and a thicker layer of conductive metal. The EIL is situated between the cathode and the organic layer (e.g., ETL). Here, the EIL preferably includes a low work function metal or metal salt, and if so, the thicker conductor layer does not need to have a low work function. One such cathode is comprised of a thin layer of LiF followed by a thicker layer of Al as described in U.S. Patent No. 5,677,572. Other useful cathode material sets include, but are not limited to, those disclosed in U.S. Patent Nos. 5,059,861; 5,059,862, and 6,140,763.

When cathode layer 113 is transparent or nearly transparent, metals must be thin or transparent conductive oxides, or a combination of these materials. Optically transparent cathodes have been described in more detail in US 4,885,211, US 5,247,190, JP 3,234,963, US 5,703,436, US 5,608,287, US 5,837,391, US 5,677,572, US 5,776,622, US 5,776,623, US 5,714,838, US 5,969,474, US 5,739,545, US 5,981,306, US 6,137,223, US 6,140,763, US 6,172,459, EP 1 076 368, and US 6,278,236. Cathode materials are typically deposited by evaporation, sputtering, or chemical vapor deposition. When needed, patterning can be achieved through many well known methods including, but not limited to, through-mask deposition, integral shadow masking as described in US 5,276,380 and EP 0 732 868, laser ablation, and selective chemical vapor deposition.

#### Deposition of organic layers

The organic materials mentioned above are suitably deposited through a vapor-phase method such as sublimation, but can be deposited from a fluid, for example, from a solvent with an optional binder to improve film formation. If the material is a polymer, solvent deposition is useful but other methods can be used, such as sputtering or thermal transfer from a donor sheet. The material to be deposited by sublimation can be vaporized from a sublimator "boat" often comprised of a tantalum material, e.g., as described in U.S. Patent No. 6,237,529, or can be first coated onto a donor sheet and then sublimed in closer proximity to the substrate. Layers with a mixture of materials can utilize

separate sublimator boats or the materials can be pre-mixed and coated from a single boat or donor sheet. Patterned deposition can be achieved using shadow masks, integral shadow masks (U.S. Patent No. 5,294,870), spatially-defined thermal dye transfer from a donor sheet (U.S. Patent Nos. 5,851,709 and  
5 6,066,357) and inkjet method (U.S. Patent No. 6,066,357). While all organic layers may be patterned, it is most common that only the layer emitting light is patterned, and the other layers may be uniformly deposited over the entire device.

#### Optical Optimization

OLED layers used with this invention can employ various well-  
10 known optical effects in order to enhance its properties if desired. This includes optimizing layer thicknesses to yield maximum light transmission, providing dielectric mirror structures, replacing reflective electrodes with light-absorbing electrodes, providing anti-glare or anti-reflection coatings over the device, providing a polarizing medium over the device, or providing colored, neutral  
15 density, or color conversion filters over the device. Filters, polarizers, and anti-glare or anti-reflection coatings may be specifically provided over the cover or as part of the cover.

The invention has been described in detail with particular reference to certain preferred embodiments thereof, but it will be understood that variations  
20 and modifications can be effected within the spirit and scope of the invention.



**PARTS LIST**

10	OLED light source
12	organic light emitting layer
14	cathode
16	anode
18	power source
20	substrate
21	tab portion of substrate
22	tab portion of substrate
30	encapsulating cover
24	first conductor
26	second conductor
28	step
34	lighting fixture
36	aperture
36'	aperture
38	support
39	clip
40	contact
41	light source support fin
44	standard lamp base
50	power conditioning circuitry
52	light transmissive housing
103	anode
105	hole-injecting layer
107	hole-transporting layer
109	light-emitting layer
111	electron-transporting layer
113	cathode layer
250	voltage / current source
260	conductive wiring